

Date: Monday, 2/4/2008 11:23:23 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 37155	
Estimate Number : 10688	
P.O. Number :	Part Number : D3162041
This Issue : 2/4/2008 S.O. No. :	Drawing Number : D3162 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / 1 Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 36733	Material :
Written By :	Due Date : 2/11/2008 Qty: 10 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est A 02.05.14 New Issue NG	
Est Rev:B 08-01-15 now on water jet DD	

## Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.0076 sf(s)/Unit Total : 0.0756 sf(s)

6061-T6 .063 Sheet

Matl: 6061-T6 .063" thick (M6061T6S.063)

105225

B 8-2-5

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3162

Dwg Rev: C

Prog Rev: C

B 8-2-5

2-Deburr if necessary

[Signature] 08/02/05 (23)

(23)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-2-5

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature] 08/02/05 (23)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr break all unmarked sharp edges .005 to 0.010

Form as per drawing

C'sink holes as per Dwg D3162

[Signature] 08/02/08 (23)  
[Signature] 08/02/08 (23)  
[Signature] 08/02/11 (23)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 08/02/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:23:23 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 37155

Part Number: D3162041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR

08-02-12

(23)

7.0

MS21059L3

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nut Plate

Pick:

Qty	Part Number	Description	Batch
1	MS21059L3	Nutplate	M103965

08/02/12

8.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
2	MS20426AD3-4	Rivet	M102404

08/02/12

9.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Assemble as per drawing

08/02/12 (23)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/12 (23) counts

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 37155

AS 8/02/13 (23)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/14

Job Completion



min 2008/2/13

(23)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

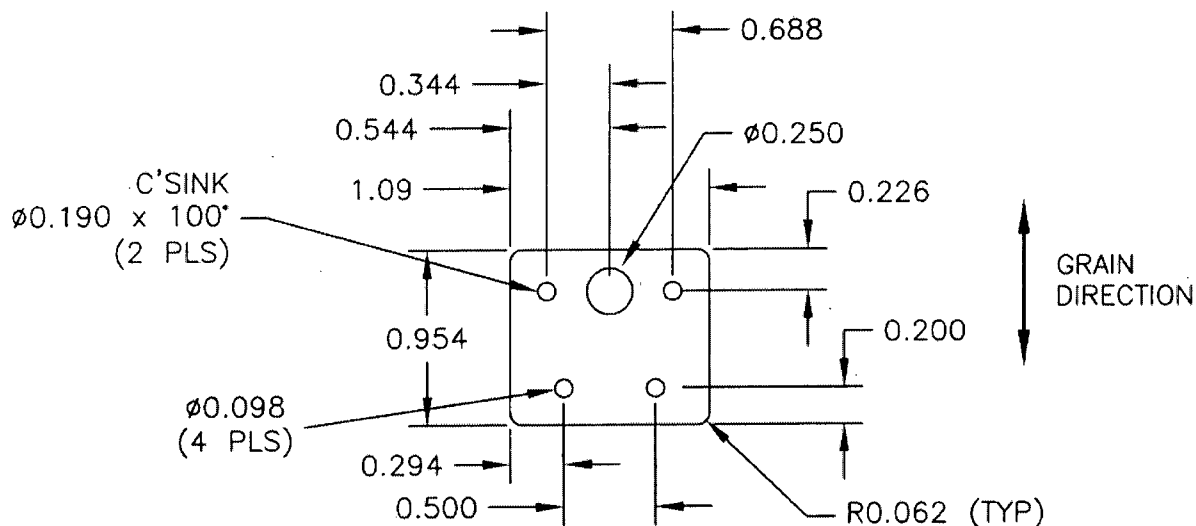
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

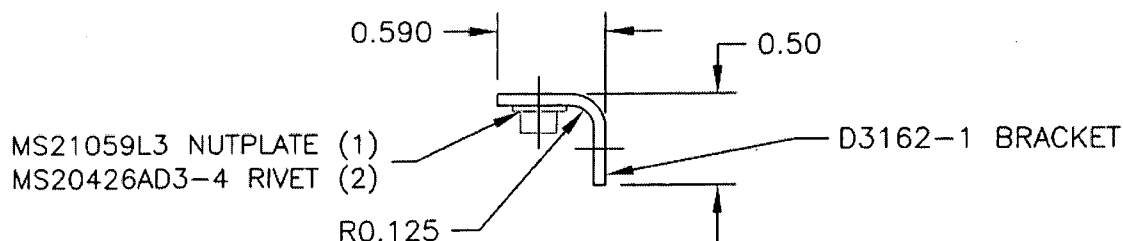


DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3162	REV. C SHEET 1 OF 2
DATE 05.10.05		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	
C	05.10.05	ADD D3162-3/-4	

RELEASED  
05.12.01



D3162-1F FLAT PATTERN  
(USED TO MAKE D3162-1 BRACKET)



D3162-041 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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WORK ORDER  
NO. 37155

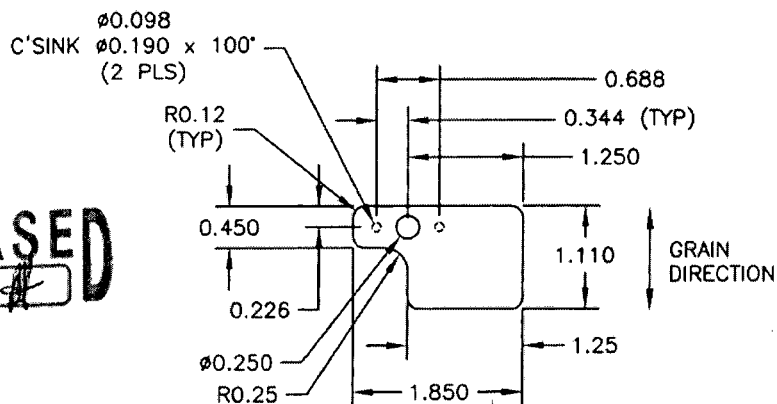
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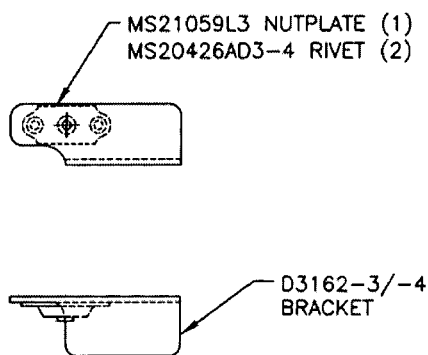


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3162	REV. C SHEET 2 OF 2
DATE 05.10.05		TITLE BRACKET ASSEMBLY	SCALE 1:2

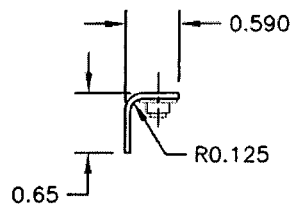
RELEASED  
05.12.01



D3162-3F FLAT PATTERN  
(USED TO MAKE D3162-3/-4 BRACKETS)



D3162-043 BRACKET ASSEMBLY (SHOWN).  
(D3162-044 BRACKET ASSEMBLY (OPPOSITE))



NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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